

**Work Order ID 66287**

February 9, 2011 7:42:24 AM



Page 1

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 2/09/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/15/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/02/09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4035	A

100

Weld per dwg A/R S.S. rod Batch: 1114649 0.00

Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

11/02/16 (22)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-02-16  
11-02-16

Pro →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4835-cu1 PAR #: \_\_\_\_\_ Fault Category: Long Fab NCR: Yes No DQA: ✓ Date: 11-02-16  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/02/17

NCR: <u>66287</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/16	# 100	Found when stacking parts that H6D2327-3 was drilled in the wrong location + welded. Should be @ 6.0" but was Done @ 8.0". Also was missed at inspection	<u>✓</u> 11/02/16	SCRAP & destructo Dims No good to use for another O-Part. - replace qty 2	<u>✓</u> 11/02/16	<u>✓</u> 11/02/16	<u>✓</u> 11/02/16	<u>✓</u> 11/02/16
		R.L. Lack of Attention and welder didn't use Sig to Drill as per wlo Details	<u>✓</u> 11/02/16				<u>✓</u> 11/02/16	<u>✓</u> 11/02/16
				# <u>M116319</u> <u>364920</u> 2x  D2327-3 B <u>64920</u> x2				

NOTE: Date & initial all entries

**Work Order ID 66287**

February 9, 2011 7:42:24 AM



Page 2

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 2/09/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/15/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S11/02/16

S11/02/16

72

+2

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

S11/02/16

11/02/16

2

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/17

MF 11-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

February 9, 2011 7:42:23 AM

Work Order ID: 66287

Parent Item: D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 2/09/11

Required Date: 2/15/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3

Manufactured

No

100

Each

14.0000

1

2



Spacer Bushing



*Handwritten signature* 11/02/16

Location

Loc Qty

Loc Code

WA

14

58974

1

64920

13

M304TS0.750W.049

Purchased

No

100

f

304.4944

1.75

3.684211



*Handwritten signature* 11/02/16

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT

267.5485679

113763

0

114323

8.15031894

114677

0.00001

114835

0.000039

116319

25.1993

116509

19.3317

116719

14.8672

116788

200

MAT017

3.68448E-05

114298

3.6845E-05

WA

36.9458

114992

11.0693

115260

25.8765

61

*Handwritten signature* 3.684

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

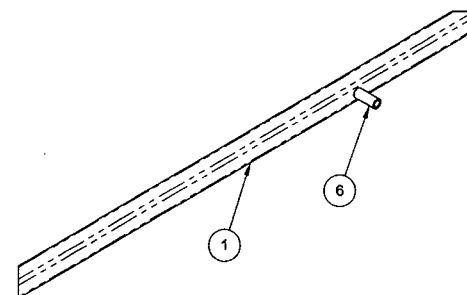
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

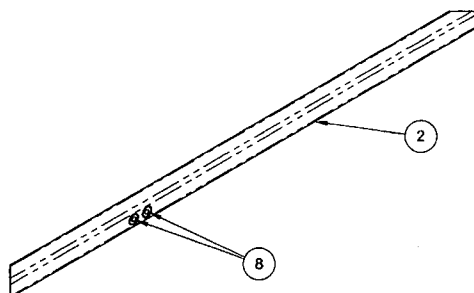
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

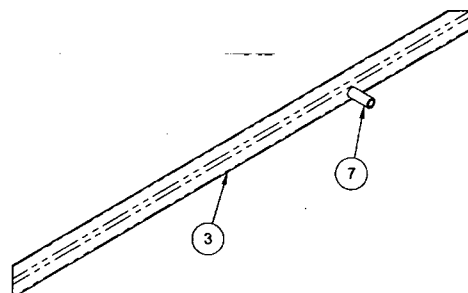
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



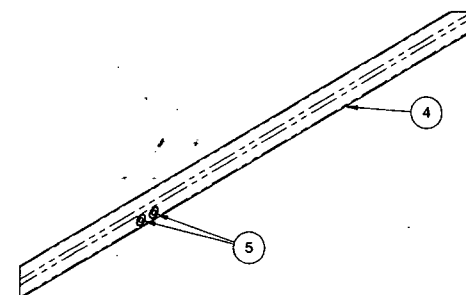
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 66287  
C21102109

**RELEASED**  
2010-03-12

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.04		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4035</b>	REV. A
TITLE <b>BASKET LID RIB ASSY</b>	SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

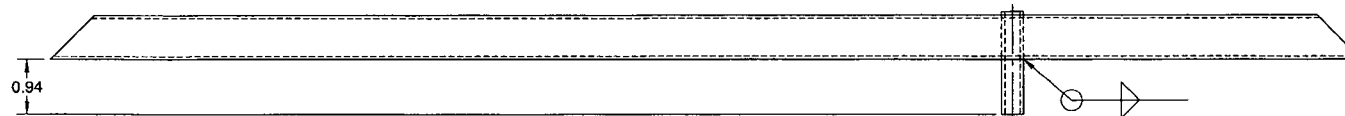
**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

D

D



D4035-1  
RIB

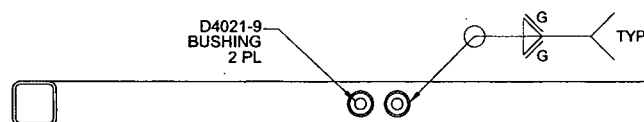
D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY. FWD**

D4035-3  
RIB

B

B



D4021-9  
BUSHING  
2 PL

TYP

**D4035-043 BASKET LID RIB ASSY. AFT**

RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 166287

**RELEASED**  
2010-03-12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COVERED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT			

8 7 6 5 4 3 2 1

A

A

8 7 6 5 4 3 2 1

D

D

D4035-5  
RIB

D2953-175  
SPACER

0.94

**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

D4035-7  
RIB

C

C

B

B

D4035-11  
BUSHING  
2 PL

G  
G  
TYP

**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

RETURN TO  
ENGINEERING  
**UNCONTROLLED COPY**  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 66287

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

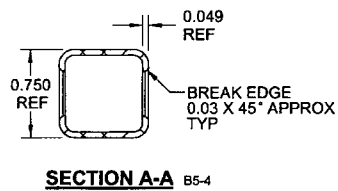
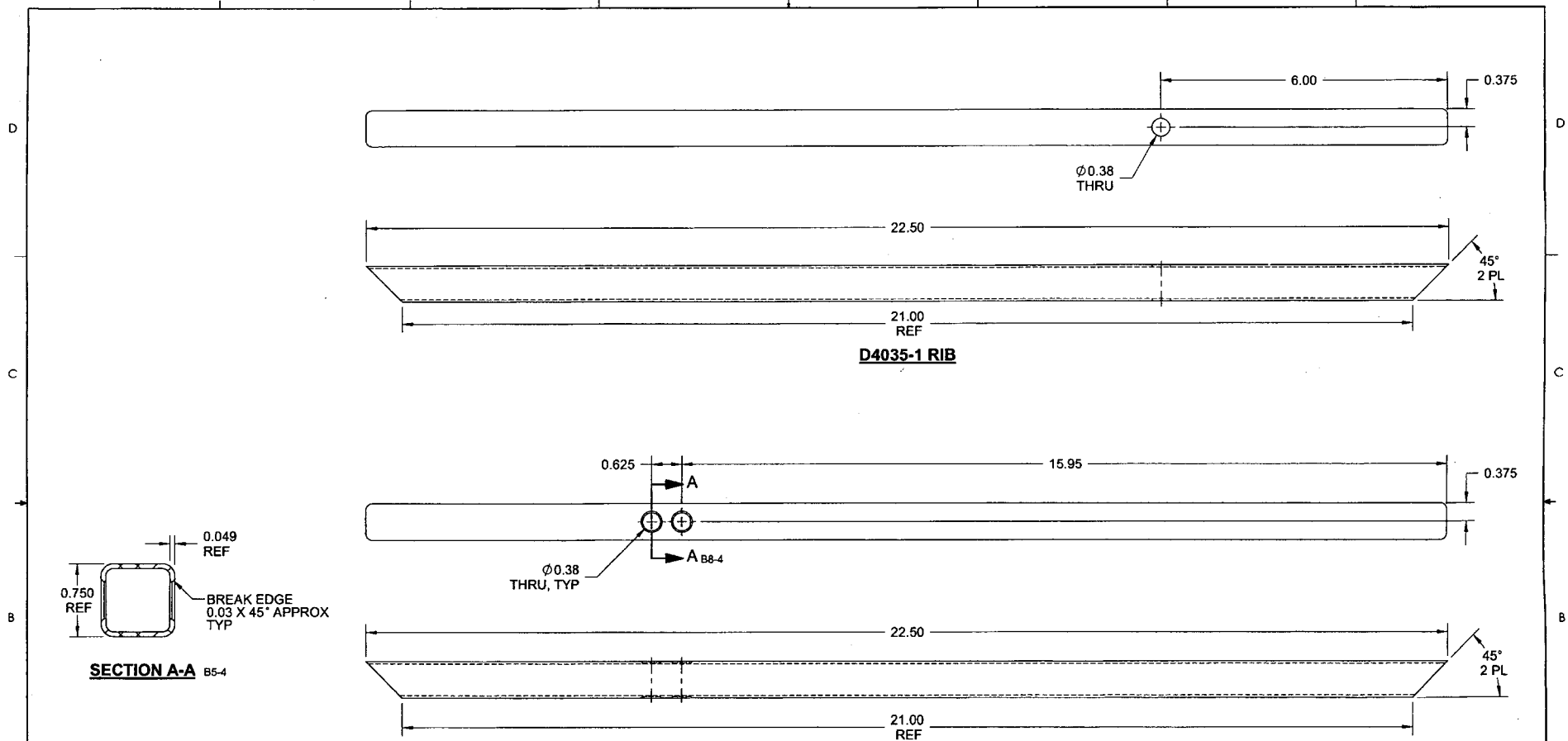
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>JPH</del>	DRAWING NO.	REV. A
MFG. APPR.	<del>JS</del>	D4035	SHEET 3 OF 5
APPROVED	<del>JS</del>	TITLE	SCALE
DE APPR.	<del>JS</del>	BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

8 7 6 5 4 3 2 1

A

A





8 7 6 5 4 3 2 1



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
PER ASTM A554/A269 MILL FINISH  
REF DART SPEC. M304TS0.750W.049
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.80 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 66287

RELEASED  
2010-03-12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

